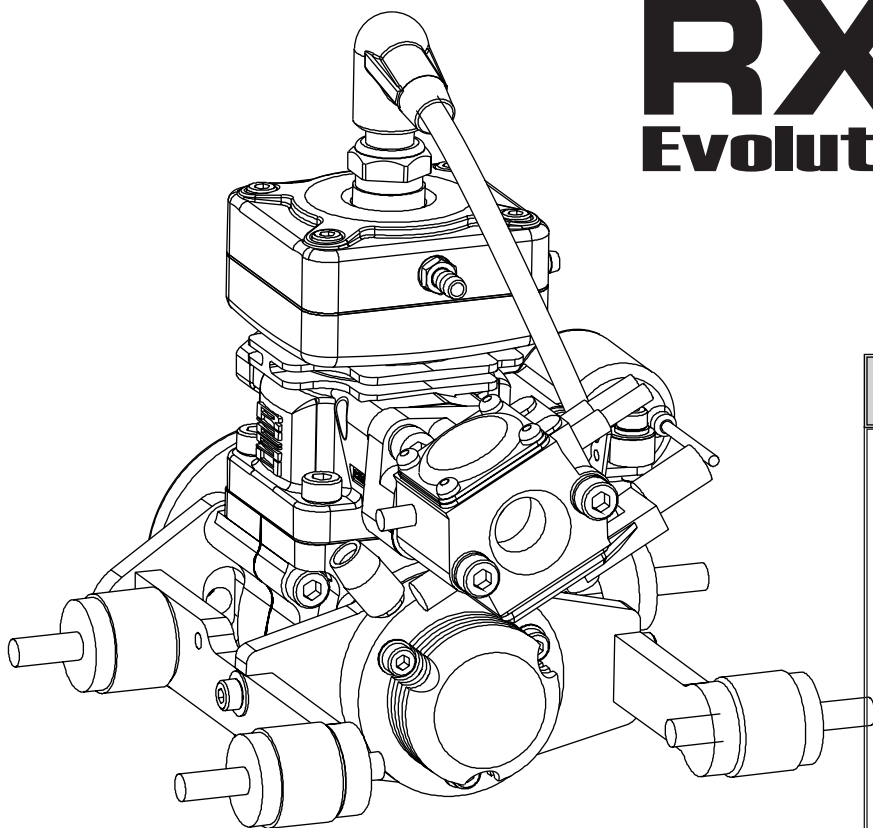


HIGH PERFORMANCE
Model Gas Engine
RX254
Evolution Version



Conversion kit include

- bearing case with 4 bearings
- crank gasket
- Head Water jacket
- Crank case water jacket
- Engine mount
- Rotor
- Pulley(for starter)
- Ignition plate
- Piston

WARNING



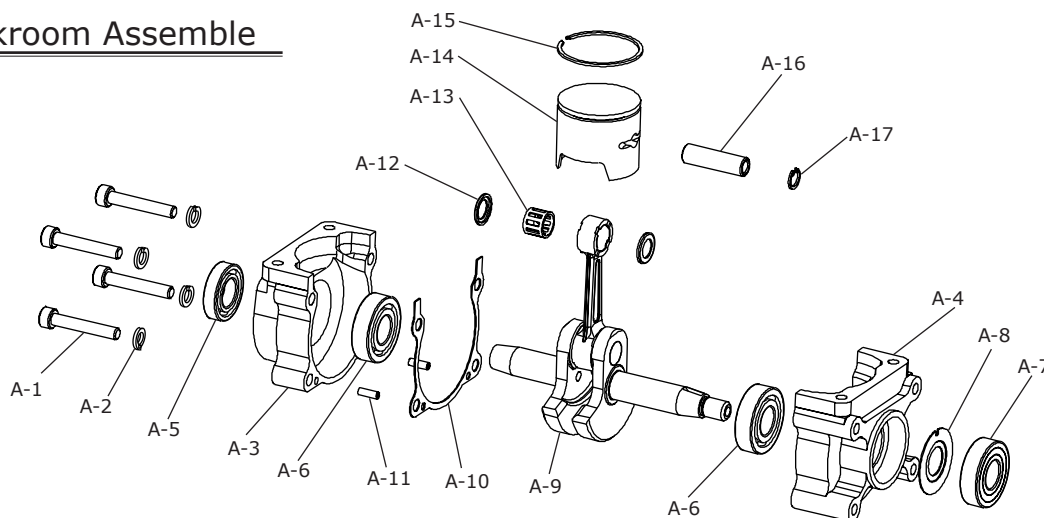
Model Gas Engine **RX254**
www.rcmk.com

- Before use engine, read description necessarily.
- This engine is designed and made for use on model boat. So we recommend to use on model boat
- Use genuine parts for replacement.
- Check the bolts fixation condition of engine every time. If the bolts are loosed, fix the loosed bolt, and after check once again.

Assembly Method



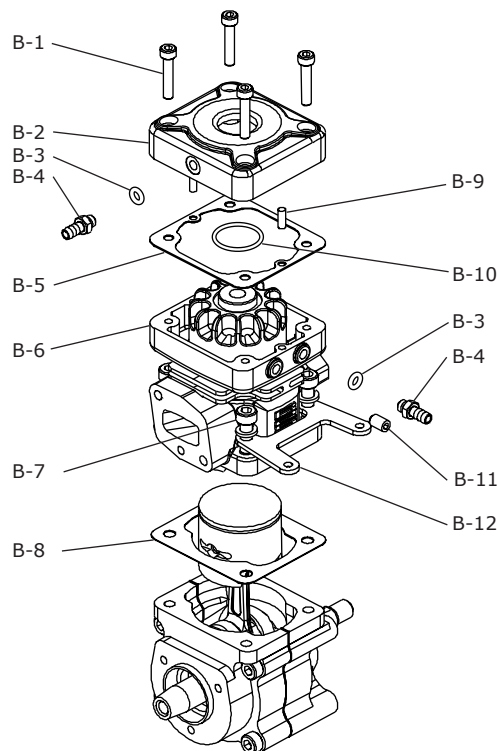
A. Crankroom Assemble



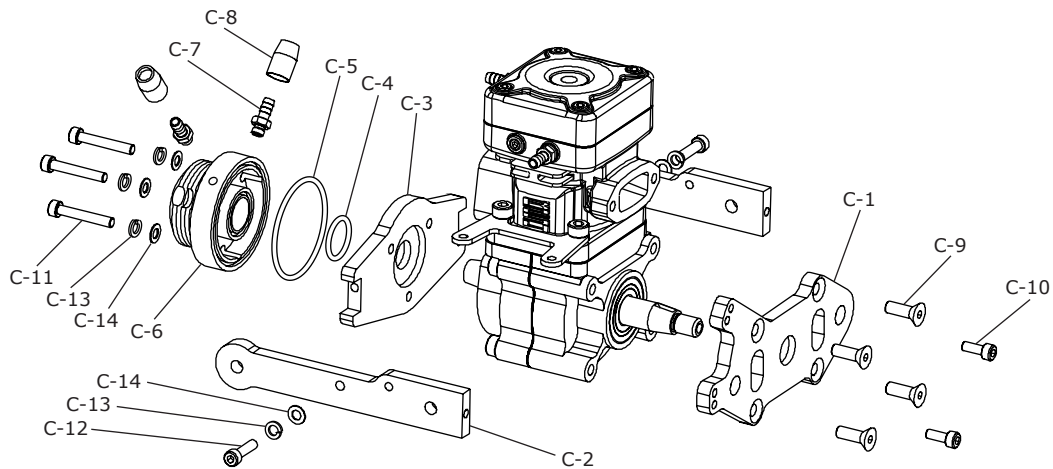
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
A-1	-	Bolt M5 x 30	4	A-10	0207000002	RX Gasket for Crankcase	1
A-2	-	Washer P5	4	A-11	0207000027	Pin 3P x 5	2
A-3	0207000001	RX Crankcase Rear	1	A-12	0207000012	Wrist Pin Bearing Spacer	2
A-4	0207000001	RX Crankcase Front	1	A-13	3704000001	Needle Roller Bearing KT 8 11 10	1
A-5	3703000001	Bearing 6901DD	1	A-14	0207000023	R254 Piston	1
A-6	3703000003	Bearing 6001C3	2	A-15	0207000025	R254 Piston Ring	1
A-7	3703000004	Bearing 6001JRLLU	1	A-16	0207000038	Piston Pin for R254	1
A-8	0207000071	Brass oil plate	1	A-17	0207000028	Snap-ring - C type	1
A-9	0207000007	Crank assembly	1				

B. Cylinder Assemble

Key	Part Number	Description	Q'TY
B-1	-	Bolt M4 X 20	4
B-2	0207000076	R254 evolution Cylinder Cap	1
B-3	4602000004	O-ring P4	2
B-4	0403000002	Fitting M5	2
B-5	0207000032	R254 Gasket for Cylinder Head	1
B-6	0207000075	R254 evolution Cylinder	1
B-7	-	Bolt M5 x 15	4
B-8	0207000031	R254 Gasket for Cylinder	1
B-9	0207000027	Pin 3P x 5	2
B-10	4602000003	O-ring S16	1
B-11	-	Set screw M5 x 8	1
B-12	0207000022	R254 Ignition Coil Mount	1

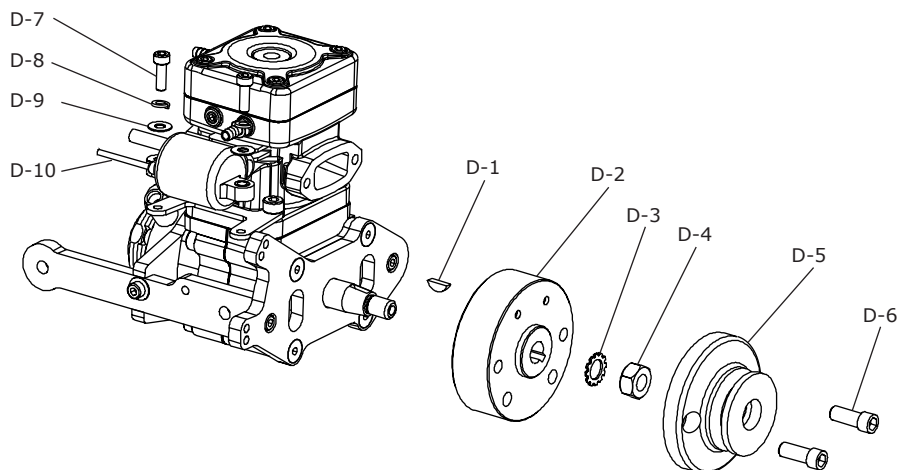


C. Crankroom Mount Assemble



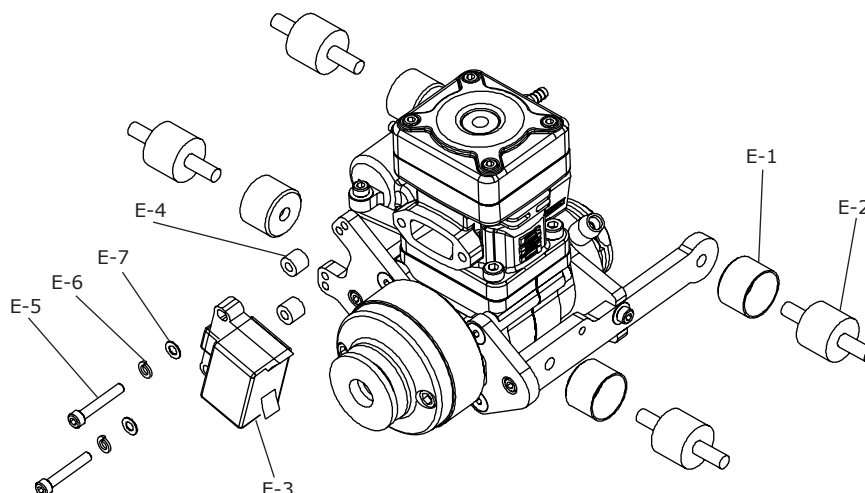
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
C-1	0201000013	SX Mount Rear	1	C-8	0403000008	Fitting Cap 5	2
C-2	0201000013	SX Mount Side	1	C-9	-	Bolt M5 X 15	4
C-3	0201000013	SX Mount Front	1	C-10	-	Bolt M4 X 10	2
C-4	4602000006	O-ring 16x2	1	C-11	-	Bolt M4 X 25	3
C-5	4602000005	O-ring S42	1	C-12	-	Bolt M4 X 15	2
C-6	0207000009	RX Crank Cooler	1	C-13	-	Spring Washer P4	5
C-7	0403000002	Fitting M5	2	C-14	-	Washer P4	5

D. Rotor Assemble



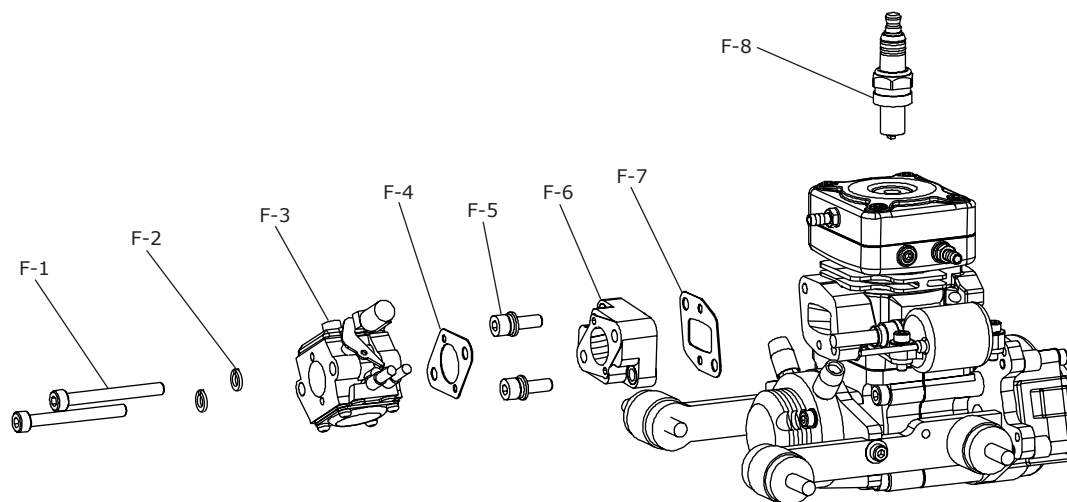
Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
D-1	0207000024	Woodruff Key	1	D- 6	-	Bolt M6 X 15	2
D-2	0207000003	RX Rotor	1	D-7	-	Bolt M4 X 12	2
D-3	-	Rock Washer P8	1	D-8	-	Spring Washer P4	2
D-4	-	Nut M8 X P1.0	1	D-9	-	Washer P4	2
D-5	0207000004	Pooly for rear exhaust - Type A	1	D-10	0202000011	R254 Ignition Coil	1

E. Ignition Assemble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
E-1	0201000011	Rubber Mount G1	4	E-5	-	Bolt M4 X 25	2
E-2	0201000011	Rubber Mount G1	4	E-6	-	Spring Washer P4	2
E-3	0207000010	R254 Source Coil	1	E-7	-	Washer P4	2
E-4	-	Spacer (8.5mm)	2				

F. Caburator Assemble



Key	Part Number	Description	Q'TY	Key	Part Number	Description	Q'TY
F-1	-	Bolt M5 x 45	2	F-5	-	Bolt M5 X 16	2
F-2	-	Spring Washer P5	2	F-6	0207000016	R254 Insulator block	1
F-3	4001000002	Carburetor WT-929	1	F-7	0207000034	R254 Gasket for Insulator	1
F-4	0207000030	R254 Gasket for Carburetor	1	F-8	4801000001	Spark Plug - CMR7H	1

Update - 2010/08/09